

Date: Thursday, 10/18/2007 8:03:20 AM  
 User: Kim Johnston

## Process Sheet

|                       |   |          |                |                             |            |                  |
|-----------------------|---|----------|----------------|-----------------------------|------------|------------------|
| Customer              | CU-DAR001 Dart Helicopters Services   |          | Drawing Name   | REPLACEMENT WINDOW ASSEMBLY |            |                  |
| Job Number            | 35212   |          | Part Number    | D3290041                    |            |                  |
| Estimate Number       | 11174   |          | Drawing Number | D3290 REV C                 |            |                  |
| P.O. Number           | N/A   |          | Project Number | N/A                         |            |                  |
| This Issue            | 10/18/2007  | S.O. No. | N/A            | Drawing Revision            | C          |                  |
| Prsht Rev.            | NC  | Type     | SMALL /MED FAB | Material                    | N/A        |                  |
| First Issue           | N/A   |          |                | Due Date                    | 10/24/2007 | Qty: 12 Um: Each |
| Previous Run          | 34952   |          |                |                             |            |                  |
| Written By            |   |          |                |                             |            |                  |
| Checked & Approved By |   |          |                |                             |            |                  |
| Comment               | Est. B 05.05.25 Added Step 11 KJ/JLM<br>Est. C 06.05.09 Ecn 798 EC<br>Est Rev:D Now on Waterjet 06-06-16 JLM<br>Est rev E rev C dwg 07.09.28 EC verified by: DD |          |                |                             |            |                  |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation: | Description :                                  |
|--|-----------------------|--|
| 1.0  | M6061T6S040           | 6061-T6 .040 Sheet<br>                         |
| Comment: Qty.: 3.9375 sf(s)/Unit Total : 47.2500 sf(s)<br>M6061T6S040 Batch: M105842 AB07-10-22                    |                       |  |
| 2.0  | WATER JET             | FLOW WATER JET<br>                             |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D3290 (use prog. for D3290-1)<br>Dwg Rev: C AB 07-10-22<br>Prog Rev: C |                       |  |
| 2-Deburr if necessary AB 07-10-22  |                       |  |
| 3.0  | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE<br><br> |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |                       |  |
| 4.0  | QC8                   | SECOND CHECK<br><br>                           |
| Comment: SECOND CHECK  |                       |  |
| 5.0  | HAND FINISHING1       | HAND FINISHING RESOURCE #1<br><br>             |
| Comment: HAND FINISHING RESOURCE #1<br>Chemical Conversion Coat as per QSI 005 4.1                                 |                       |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

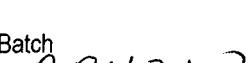
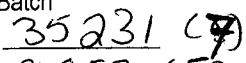
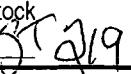
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

|  |                       |  |  |
|--|-----------------------|--|--|
| Customer: CU-DAR001 Dart Helicopters Services  |                       | Drawing Name: REPLACEMENT WINDOW ASSEMBLY  |  |
| Job Number: 35212  |                       | Part Number: D3290041  |  |
| Job Number:   |                       |  |  |
| Seq. #:  | Machine Or Operation: | Description :  |  |
| 6.0  | POWDER COATING        | POWDER COATING   |  (12) |
| Comment: POWDER COATING<br>Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3   |                       |  (12) | 07-10-24   |
| 7.0  | QC3                   | INSPECT POWDER COAT/CHEMICAL CONVERSION  |       |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   |                       | SAh  | 07-11-17 (12)  |
| 8.0  | D2126                 | Seal   |       |
| Comment: Qty.: 6.5000 f(s)/Unit Total : 78.0000 f(s)<br>Locking Seal<br>Pick:<br>X Qty Part Number Description Batch<br>1 D2126-0780 Locking Seal  (12) |                       | SAD  | 07-11-18 (12)  |
| 9.0  | D32903                | Window   |     |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)<br>Window<br>Pick:<br>X Qty Part Number Description Batch<br>1 D3290-3 Window  (12)        |                       | SAD  | 07-11-17 (12)  |
| 10.0   | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1  |     |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Assemble as per Dwg D3290<br>Clean D3290-041 and place in plastic wrap   |                       | SAD  | 07-11-18 (12)  |
| 11.0   | QC5                   | INSPECT WORK TO CURRENT STEP   |     |
| Comment: INSPECT WORK TO CURRENT STEP  |                       | SAD  | 07-11-18 (12)  |
| 12.0   | PACKAGING 1           | PACKAGING RESOURCE #1  |     |
| Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location:  (12)   |                       | AS 07/11/20  | (12)   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 35212

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

12/11/20

Job Completion



U 8/11/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

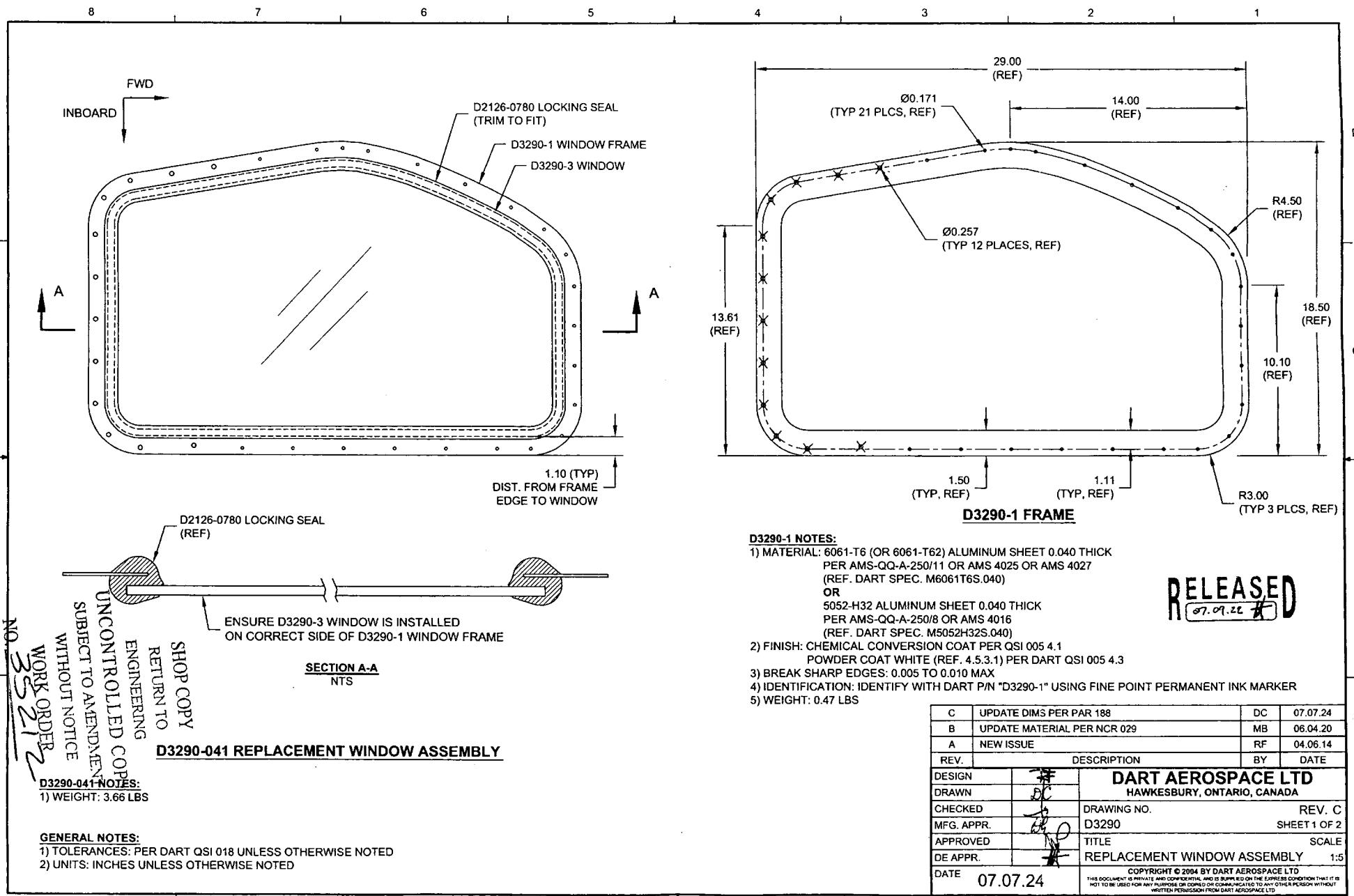
|                           |              |             |
|---------------------------|--------------|-------------|
| DART AEROSPACE LTD        | Work Order:  | 35212       |
| Description: Window Frame | Part Number: | D3290-1     |
| Inspection Dwg: D3290     | Rev: C       | Page 1 of 1 |

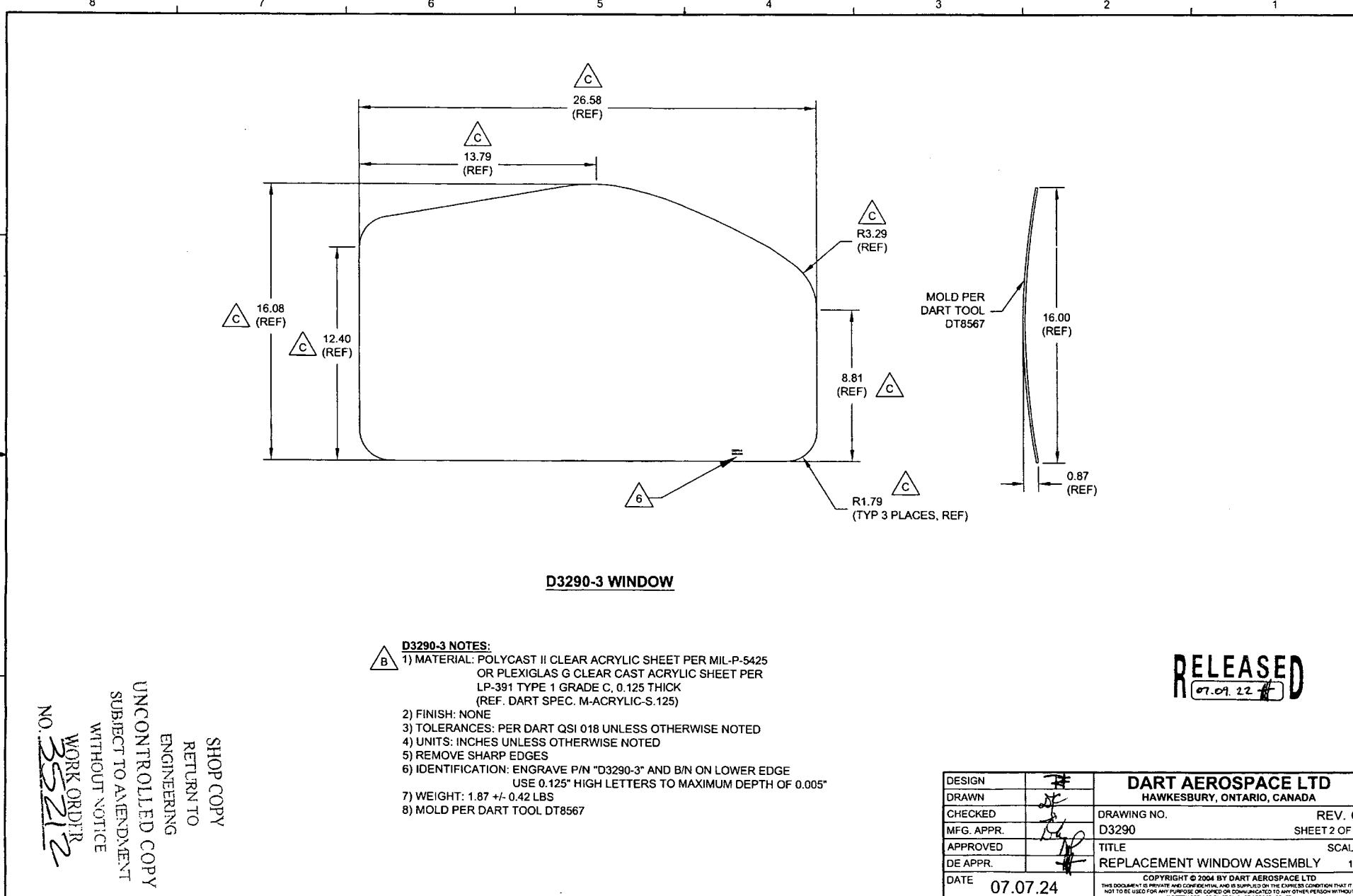
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

|                        |                       |                         |
|------------------------|-----------------------|-------------------------|
| Measured by: <u>HB</u> | Audited by: <u>SN</u> | Prototype Approval: N/A |
| Date: <u>07-10-22</u>  | Date: <u>07/10/22</u> | Date: N/A               |

| Rev | Date     | Change                          | Revised by | Approved |
|-----|----------|---------------------------------|------------|----------|
| A   | 06.09.19 | New Issue P/O D3290-041         | KJ/JLM     |          |
| B   | 07.07.18 | 13.61 dimension removed         | KJ/JLM     |          |
| C   | 07.09.28 | Dimensions update per Dwg Rev C | KJ/EC/DD   | 11/22    |





|            |                 |  |
|------------|-----------------|--|
| DESIGN     | <b>7F</b>       | <b>DART AEROSPACE LTD</b>              |
| DRAWN      | <b>7F</b>       | HAWKESBURY, ONTARIO, CANADA            |
| CHECKED    | <b>7F</b>       | DRAWING NO. <b>D3290</b>               |
| MFG. APPR. | <b>7F</b>       | REV. C                                 |
| APPROVED   | <b>7F</b>       | SHEET 2 OF 2                           |
| DE APPR.   | <b>7F</b>       | TITLE                                  |
| DATE       | <b>07.07.24</b> | SCALE                                  |
|            |                 | <b>REPLACEMENT WINDOW ASSEMBLY</b> 1:5 |

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